Date:

Tuesday, 30/09/2008 11:14:23 AM

User:

Julie Lecoca

Process Sheet

Customer Job Number : CU-DAR001 Dart Helicopters Services

: 42362

: 10725

Estimate Number P.O. Number

: 30/09/2008 This Issue Prsht Rev.

: NC

First Issue

: // : 41637 Type

S.O. No. :

: MACHINED PARTS

: D2652

Drawing Number

Part Number

Drawing Name

: D2652 REV A

: BUSHING

Project Number **Drawing Revision**

: N/A

Material

Due Date : 10/10/2008 Qtv:

200 Um:

Each

Written By

Previous Run

Checked & Approved By Comment

: Est Rev:B 02.06.13 Now machined in house.

NG

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

303 Round Bar 0.500"

1.0 M303R0500

Comment: Qty.:

0.0578 f(s)/Unit Total: 11.5500 f(s)

Material:303 ss .500" Round Bar

Comment: 1-TURN AS PER FOLIO FA250 & DWG D2652

(M303R0500)

Batch: M 109 508

2.0

HARDINGE



FOLIO REV:

DWG REV:_

2-DEBURR AS REQUIRED

INSPECT PARTS AS THEY COME OFF MACHINE

3.0

QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK

Comment: SECOND CHECK

5.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:



Dart Aerospace Ltd

	•								
W/O:			W	ORK ORDER CHANGE	S				
DATE STEP P			CEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									ļ
	,				!				
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A :	_ Date: _	
Resolution:			Disposition: Q			QA: N/C Closed: Date: _			
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NC	R)			
DATE	STEP D	Description of NC	Corrective Action Section B			Verification		Approval	Approval
DATE		Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	Section C	Chief Eng	QC Inspecto

NOTE: Date & initial all entries

Date: User: Tuesday, 30/09/2008 11:14:23 AM

Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 42362

Part Number: D2652

Job Number:



Seg. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE

08/10/08 /

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 8110.07

Dart Aerospace Ltd	Da	ırt	Aer	osp	ace	Ltd
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	<u>'.</u>									
W/O:			WC	RK ORDER CHANG	iES					
DATE	STEP	PROCEDURE CHANGE			By	y	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	:									
				3						9
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: \	∕es N	o DQ	A:	Date:	
Resolution:			Disposition:			QA: N/C Closed:			Date:	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (N	ICR)				
DATE	STEP	Description of NC	Corrective Action Section			verificat		ation	n Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Secti	on C	Chief Eng	QC Inspector
3										
*										

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 42367			
Description: Bushing	Part Number:	D2652		
Inspection Dwg: D2652 Rev: A		Page 1 of 1		

FIRST ARTICLE INSPECTION CHECKLIST

		X First Arti	icle	_ Prot	otype	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.600	+/-0.010	.599				
0.060	+/-0.005	,058				
Ø0.305	-0.002/+0.000	0,304				
Ø0.191	+0.005/-0.000	0.191				··c
Ø0.500	+/-0.010	9.455				
0.030 x 20°	+/-0.010	.030x26	/			
R0.010	+0.010/-0.000	R.008				
						4
					4	
	Y					

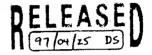
Measured by:	Audited by:	Prototype Approval:	N/A
Date: 5/10/66	Date: 08/10/06	Date:	

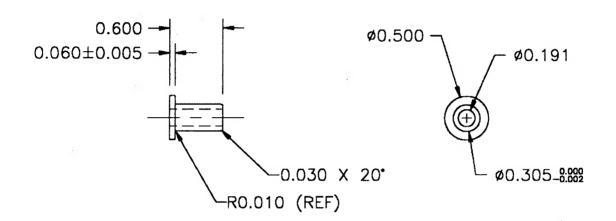
Rev	Date	Change	Revised by	Approved
Α	03.12.12	New Issue	KJ/RF	- 4





	DESIGN	DRAWN BY		OSPACE USA, I	NC.
	CHECKED	APPROVED	DRAWING NO.		REV. A
'	BW	101W	D2652	SHEE	T 1 OF 1
ı	DATE	•	TITLE		SCALE
	97:03:25	-	BUSHING		1:1





MATERIAL: AISI 303 SS

NOTE: BREAK ALL SHARP CORNERS 0.010 MAX

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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SUBJECT TO AMENDMENT

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